

Work Order ID 54414

December 09, 2009 9:42:24 AM



Page 1

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step

Stop



Start Date: 12/09/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/16/2009 Req'd Qty: 1.00



Customer:

Reference: Return 2009 / RA109105

Approvals:

Process Plan: 4

Date: _____

Tooling: _____

Date: _____

Run Start



QC: 7

Date: 09-12-09

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Original B37917 @ CHG001.

All D-Parts are present, but all the hardware was used for ass'y, by the customer.
Over all Parts are in acceptable condition, but require clean up & minor touch ups.

110

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

Clean the struts & touch up & or powder coat as required.

Ensure to keep the parts correctly identified while cleaning & touching up

Clean & touch up the step as required with Imron white.

POWDER COAT

ALL STRUTS

TOUCH-UP

STEP

START: 9:30AM

Temp: 400°F

FIN: 10:00AM

=> 09-12-18

(XO) 6

18/12/2009

54414

S.057 12.10

#1 409.2 F

#2 307.10 F

#3 F

Work Order ID 54414

December 09, 2009 9:42:24 AM

Page 2

Item ID: D205-633-011

Accept

Revision ID:

Item Name: Heli-Access-Step

Start Date: 12/09/2009 Start Qty: 1.00

Required Date: 12/16/2009 Req'd Qty: 1.00

Reference: Return 2009 / RA109105

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC3- Inspect Part Finish

0.00

BK 09-12-18

D

QC

Memo

0.00

Quality Control

Ensure the parts are correctly identified with the respective part & batch #'s.

130

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

Ensure the parts are correctly identified with the respective part & batch #'s.

New labels & paperwork are required with the new batch #, & @ CHG001

09112121

140

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

Ensure the parts are correctly identified with the respective part & batch #'s.

09/12/21 (1)

09.12.22

Work Order ID 54414

December 09, 2009 9:42:24 AM

Page 3

Item ID: D205-633-011

Accept

Revision ID:

Item Name: Heli-Access-Step

Start Date: 12/09/2009 Start Qty: 1.00

Required Date: 12/16/2009 Req'd Qty: 1.00

Reference: Return 2009 / RA109105

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

Identify as per dwg & Stock Location: 45

0.00



Packaging

Memo

0.00

Packaging

CHG 001

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/22

09/12/22

u 9.12.22

Picklist Print

December 09, 2009 9:42:23 AM

Page 1 / 6

Work Order ID: 54414

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step


Comments:

Start Date: 12/09/2009

Required Date: 12/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-14A  Bolt		Purchased	No			110	Each	477.0000	1.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

477

113359

477

110

Each

182.0000

2.0000

M113339

12/9/2009 (1)

AN4-5A

Bolt



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

182

100089

6

106605

6

108672

1

109061

9

110844

57

111650

3

112933

100

M110844

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D205-633-011	CHG	CHG001		
DESC.	Heli-Access-Step	STC	SH96-57		
LOT	B37917	STC	SR00592/3NY		
MODEL	Bell 205/212/214/412	STC	SR00594NY		
MADE IN CANADA					
D2729-1					

Picklist Print

December 09, 2009 9:42:23 AM

Page 2 / 6

Work Order ID: 54414

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step



Comments:

Start Date: 12/09/2009

Required Date: 12/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-6A  Bolt		Purchased	No			110	Each	1,701.000	2.0000 	✓		

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1701

111279 1

112314 300

112641 100

112720 100

112829 300

112933 300

113149 600

1112314

AN4-7A

Bolt

Purchased

No

110

Each

387.0000

2.0000


✓

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 387

112794 1

113226 386

113226

December 09, 2009 9:42:23 AM

Shop Packet Print

Page 2

Picklist Print

December 09, 2009 9:42:23 AM

Page 3 16

Work Order ID: 54414

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments:

Start Date: 12/09/2009

Required Date: 12/16/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN5-14A  Bolt		Purchased	No			110	Each	112.0000	1.0000			
--	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST	112	
106166	8	
112471	40	
112467	14	
112489	50	

AN5-6A  Bolt		Purchased	No			110	Each	81.0000	1.0000			
---	--	-----------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST	81	
108376	8	
111425	23	
112243	50	

Picklist Print

December 09, 2009 9:42:23 AM

Page 4 16

Work Order ID: 54414

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments:

Start Date: 12/09/2009

Required Date: 12/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416

Purchased

No

110

Each

2,177.000

15.0000



Washer

Substitution
NA51149704635 Q51 42.11

9/12/21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2177

108161

329

110523

340

111279

101

111916

482

112314

925

16941

0

AN960JD516

Purchased

No

110

Each

976.0000

4.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

976

110363

46

110523

57

111279

39

112082

64

112314

14

112828

256

113149

500

11/25/28

December 09, 2009 9:42:23 AM

Shop Packet Print

Page 4

Picklist Print

December 09, 2009 9:42:23 AM

Work Order ID: 54414

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step


Comments:

Start Date: 12/09/2009

Required Date: 12/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2021-101  Eyebolt		Manufactured	No			110	Each	12.0000	1.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

12

40433

12

D2022-101



Spacer

Manufactured No

110

Each

492.0000

2.0000

70433

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST504

492

45885

292

50746

100

52325

100

45885

D2022-103



Spacer

Manufactured No

110

Each

198.0000

2.0000

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST109

198

47964

191

50735

7

47964

Picklist Print

December 09, 2009 9:42:23 AM

Page 6 16

Work Order ID: 54414

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step


Comments:

Start Date: 12/09/2009

Required Date: 12/16/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4  Nut		Purchased	No			110	Each	4,049.000	8.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4049

110507

184

111827

3865

15924

0

MT 11/18/27

MS21042L5



Nut

Purchased

No

110

Each

726.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

726

110382

10

111636

11

112314

705

MT 11/23/14

December 09, 2009 9:42:23 AM

Shop Packet Print

Page 6

Date: Thursday, 3/13/2008 10:18:36 AM
 User: Kim Johnston

Process Sheet

16

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 STEP(STANDARD HEIGHT)
Job Number : 37917	
Estimate Number : 10180	
P.O. Number :	Part Number : D205633011
This Issue : 3/13/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : N/A
Previous Run : 37662	Material :
Written By :	Due Date : 4/15/2008 Qty: 10 Um: Each
Checked & Approved By : <u>080313</u>	
Comment : Est Rev: F 02.07.11 Reformat; Removed D3010 RF	

REFERENCE ONLY

Additional Product : - clean : t.u.p slwts. : step
 - New P/W
 - New hardware chg

130/pkg

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 37917A STEP WELDMENT



Comment: Sub-Component STEP WELDMENT
 D2563 B 37917A ✓

SC

2.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPP205-633-011 CHG001

5 08/05/09 08.4.14 JLD

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0 D2021101 Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2021-101 Eyebolt 35131

SC

5.0 D2022101 Spacer



10x

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-101 Spacer 33985

8/5/1

SC

Date: Thursday, 3/13/2008 10:18:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 37917

Part Number: D205633011

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-103 Spacer 35885

SP

7.0

D2562001

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2562-001 Strut 34358 (34)

(7x) 68029

SP

8.0

D2565101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-101 Strut 37679 (9x)

38027 (1x)

SP

9.0

D2565103

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-103 Strut 37388 (7x)

38028 (34)

SP

10.0

D2565105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-105 Strut 37680 (1x)

38029

SP

11.0

D2565107

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-107 Strut 37362 (7x)

37389 (7x)

38030 (14)

8/5/11

10x

SP

Date: Thursday, 3/13/2008 10:18:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 37917

Part Number: D205633011

Job Number:



REFERENCE ONLY

Seq. #: Machine Or Operation: Description :

12.0 D2565109 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-109 Strut 35176 ✓

sq

13.0 D2565111 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-111 Strut 37391 (9x)

3803 (x)

sq

14.0 AN45A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-5A Bolt 106242

sq

15.0 AN46A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-6A Bolt 106667

sq

16.0 AN47A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-7A Bolt 102140

8/5/11

sq

Job Number:



Seq. #:

Machine Or Operation:

Description :

REFERENCE ONLY

17.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-14A Bolt 105653

SQ

18.0

AN56A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-6A Bolt 103524

SQ

19.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-14A Bolt 104547

SQ

20.0

AN960JD416

Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 150.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 AN960JD416 Washer 107321

SQ

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer 107008 (23x) 107534

(17x)

8/5/1

10x

SQ

Date: Thursday, 3/13/2008 10:18:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 37917

Part Number: D205633011

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description :

22.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut 106051

SCP

23.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut 106785

8/5/1

SCP

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/05/08 (ECC)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-011

Location: G

8/5/8

10x

SCP

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/08

Job Completion



mf 08-05-08

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

REFERENCE ONLY

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

• COPYRIGHT © 2002 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 07.08.21